

D206-628-012 BULK

Dart Aerospace Ltd.

24

Date: Wednesday, 5/16/2007 1:29:44 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L /407 STEP ASSY, LH
 Job Number : 32391A
 Estimate Number : 11702
 P.O. Number : *N/A*
 This Issue : 5/16/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : LARGE FAB ASSY
 Previous Run : 32249A
 Part Number : D2724041
 Drawing Number : D2724 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : *N/A*
 Due Date : 6/15/2007 Qty: 4 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty Part # Description Batch:
 1 D2622-120C Extrusion *331984*

Check Material for any Dents or Defects

F.F.

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724
 Deburr and bevel ends for welding

[Signature] 07-05-31

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description Batch:
 2 D2734 End Cap *329340*

[Signature] 07-05-31

4.0 D34581 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch:
 2 D3458-1 Plate *331013 = 8*

[Signature] 07-05-31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:29:44 PM
User: Kira Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 32391A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

31074=8

324

PE.07.05.31 4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD Batch: M102766

M103317

Grind end cap welds flush

u.m 07.06.04 (4)

PE

PE.07.06.01 4

PE.07.06.01 4

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

(LH) 07/06/05 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.06.05 (4)

(LH)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

u.m

07.06.07

4

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07.06.07 (4)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

PE.07.06.11 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 32391A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description:

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig
DT
A/R AL ROD Batch: M102756

Grind per dwg D2724

12.0

QC5/9

WELD INSPECTION

QC5 07-06-13 (4)

Comment: WELD INSPECTION

LHM 07/06/13

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

(4X)

Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

M-L07/06/16

14.0

SPRAY PAINTING

SPRAY PAINTING

P/O: 4102 C207107105 (1)

Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE (PER QSI 005)

-CLEAR DELFLEET

15.0

QC14

INSPECT SPRAY PAINT

FAA-13 (1)

Comment: INSPECT SPRAY PAINT

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

M104733

Comment: Wing Walk as per Dwg D2724 and QSI 00 5.4.4

FL 07/07/16 (1)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L07/07/16

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPR 3239 107/17/24 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/15	14	split to send 1 to outside supplier for painting	u	07/06/15	1	u 07/06/15	1/04/13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/07/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 32391A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



②

Comment: FINAL INSPECTION/W/O RELEASE

D2724041

Job Completion



U D2724

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

